

FIG - 3

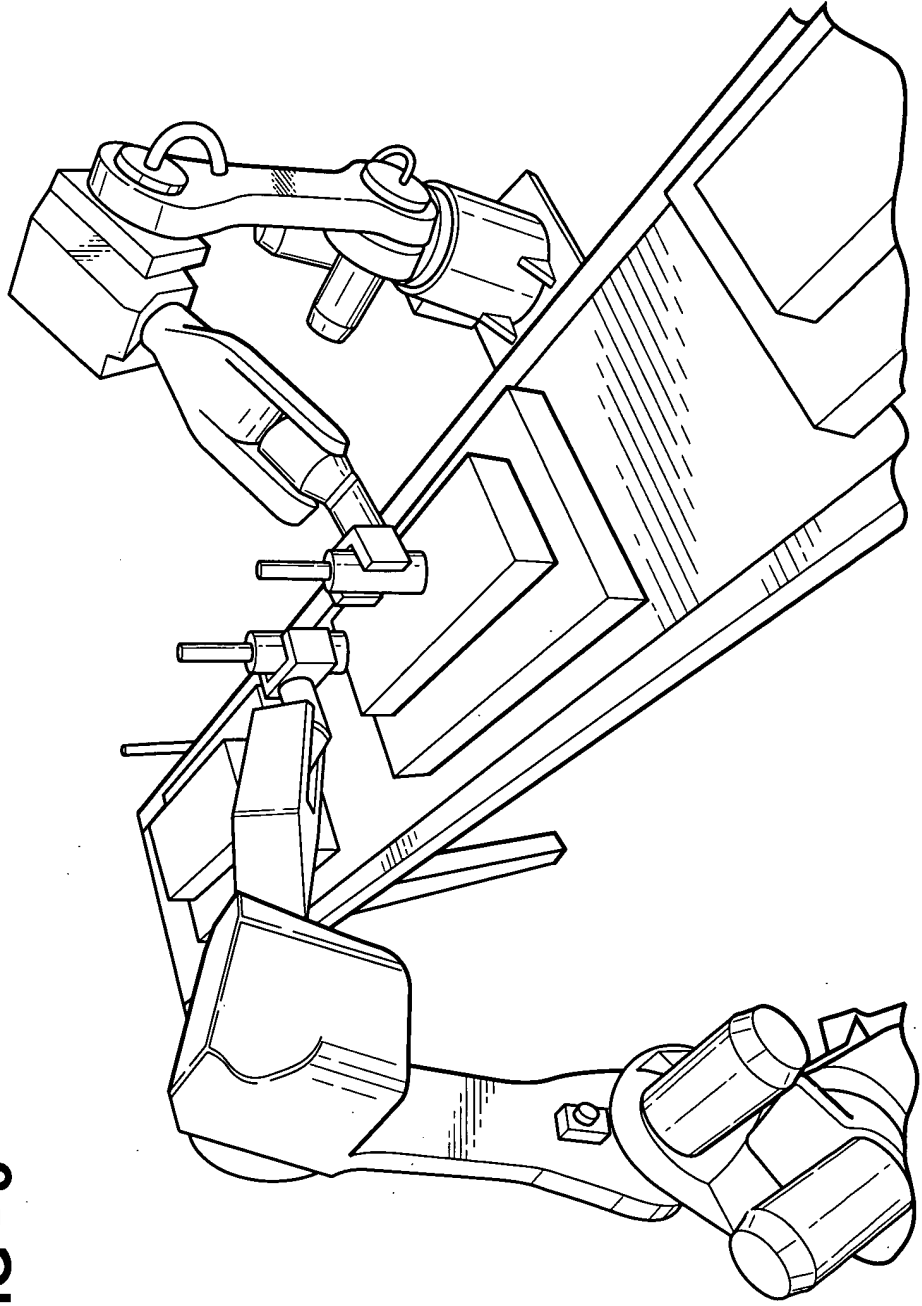
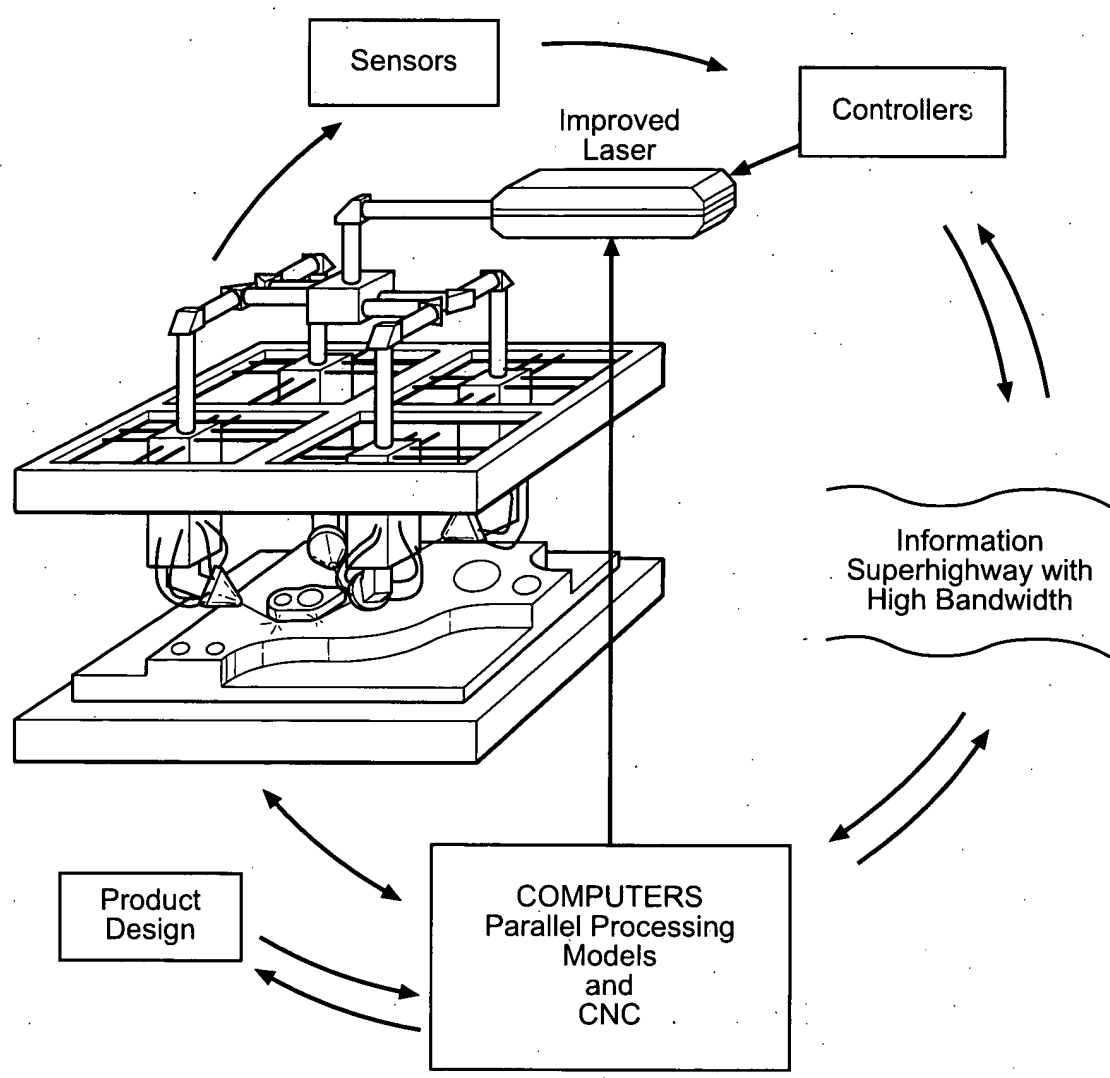




FIG - 4



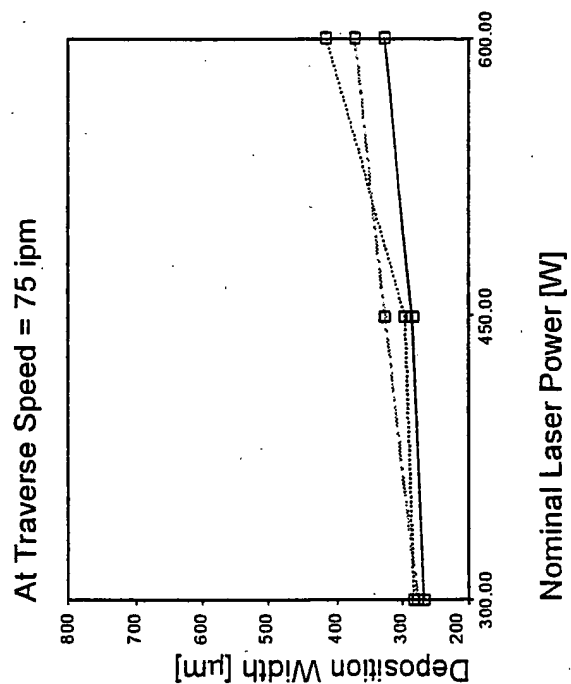
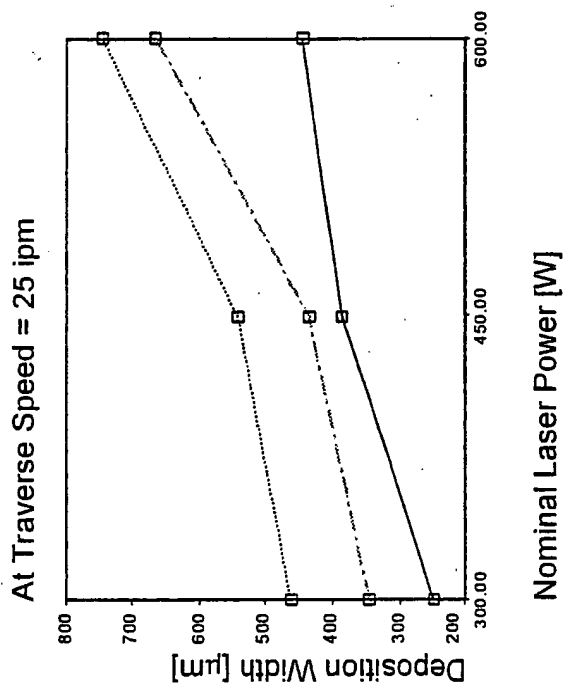
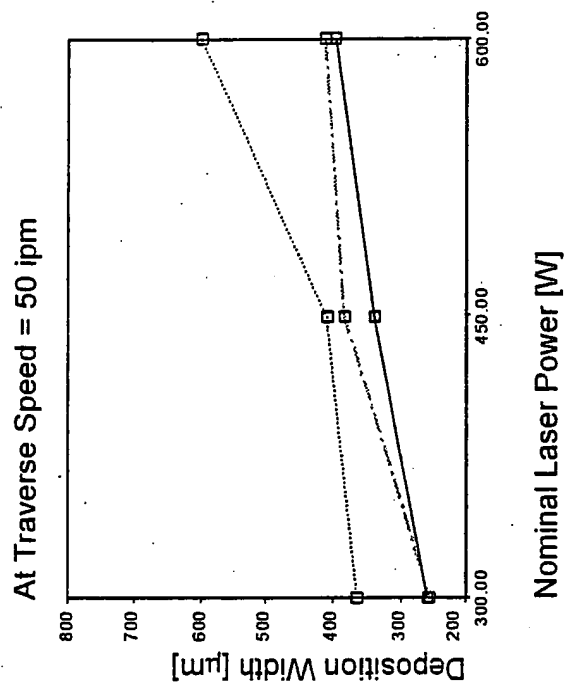
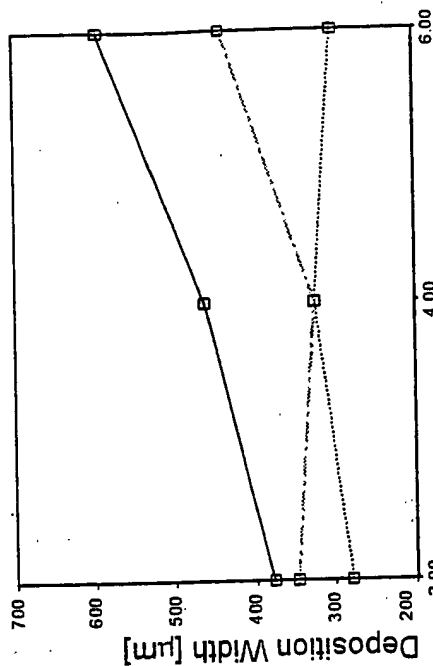


FIGURE 7

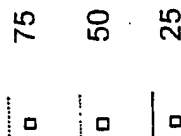


At Defocus = 20/1000"

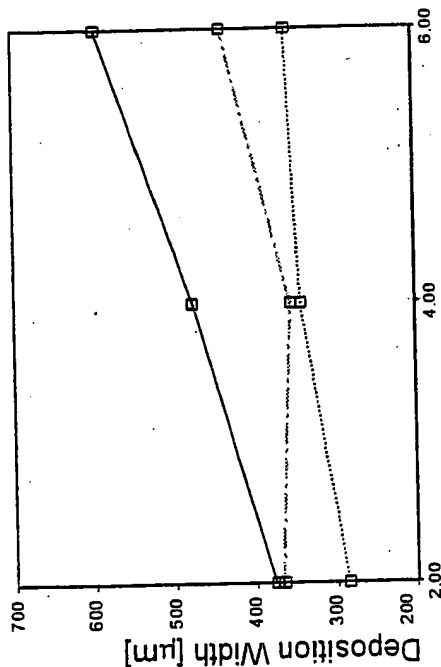


Powder Feed Rate [g/30s]

Traverse Speed [ipm]

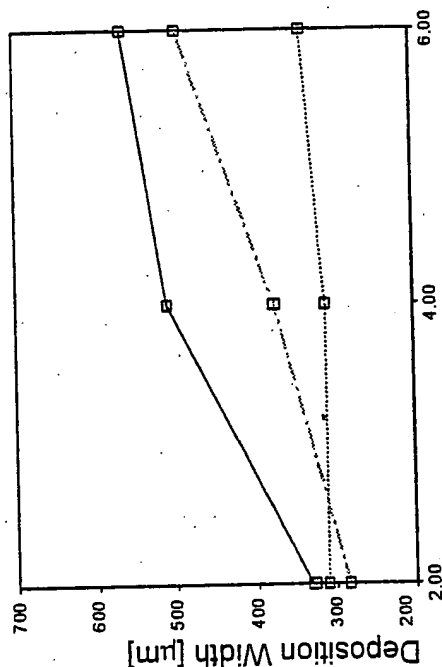


At Defocus = 10/1000"



Powder Feed Rate [g/30s]

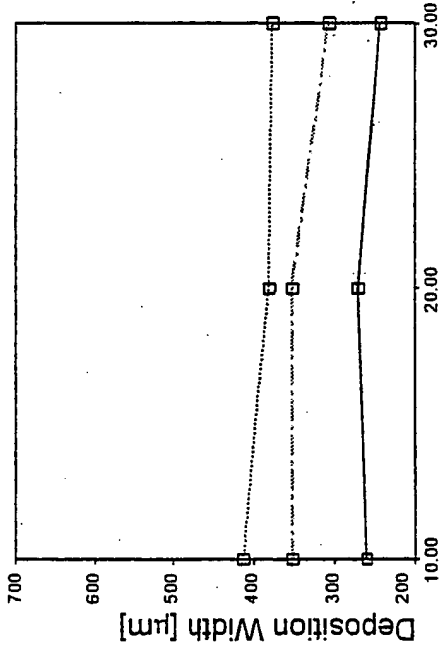
At Defocus = 30/1000"



Powder Feed Rate [g/30s]

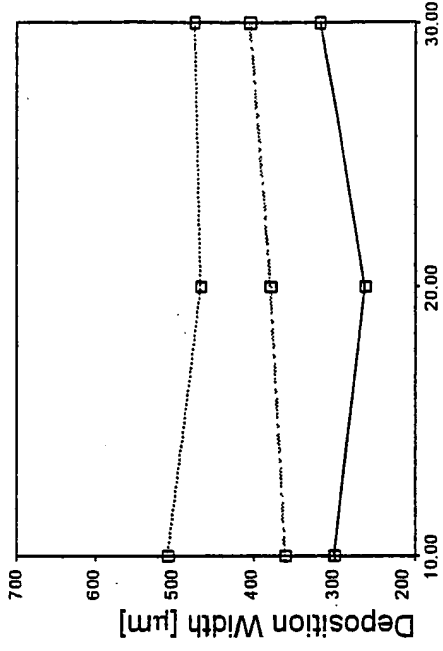
FIGURE 8

At Powder Feed Rate = 2 g/30s



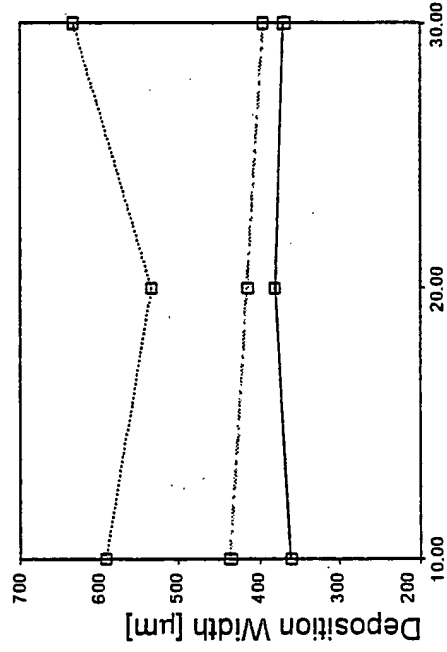
Defocus [1/1000"]

At Powder Feed Rate = 4 g/30s



Defocus [1/1000"]

At Powder Feed Rate = 6 g/30s



Defocus [1/1000"]

Nominal Laser Power [W]

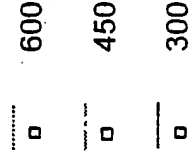


FIGURE 10

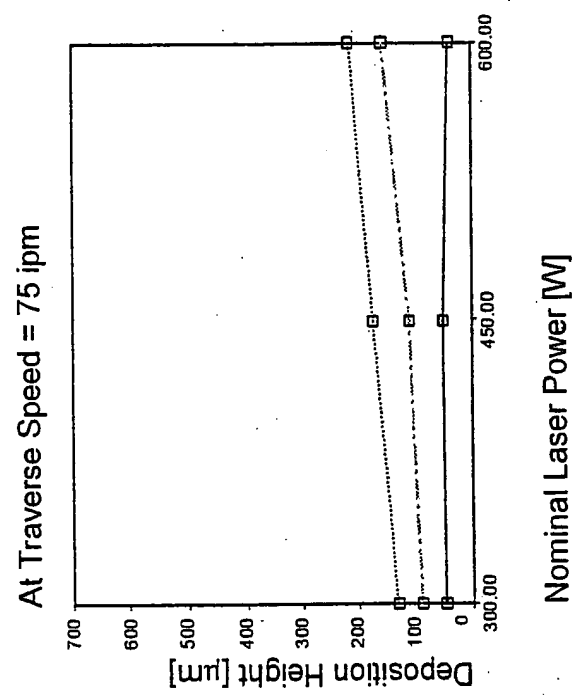
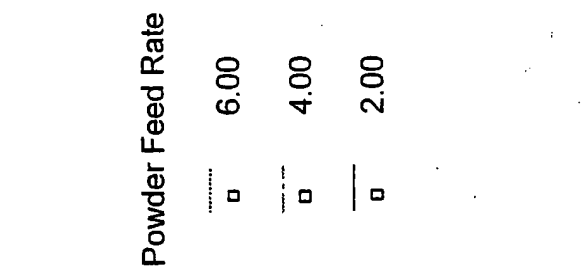
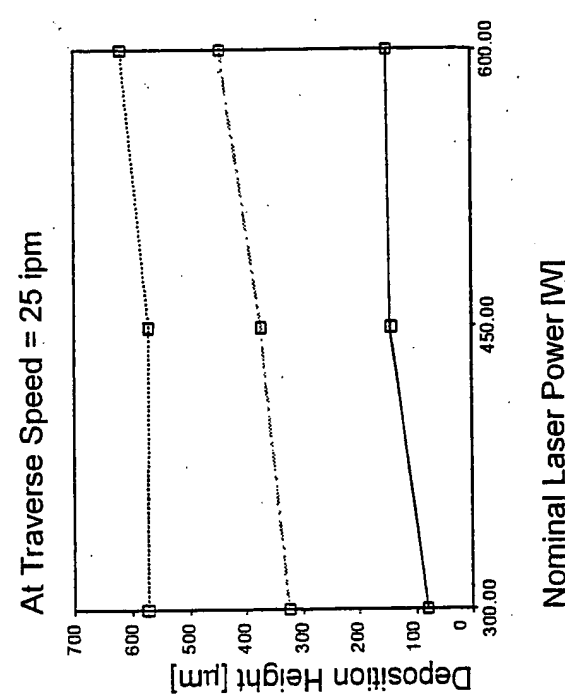
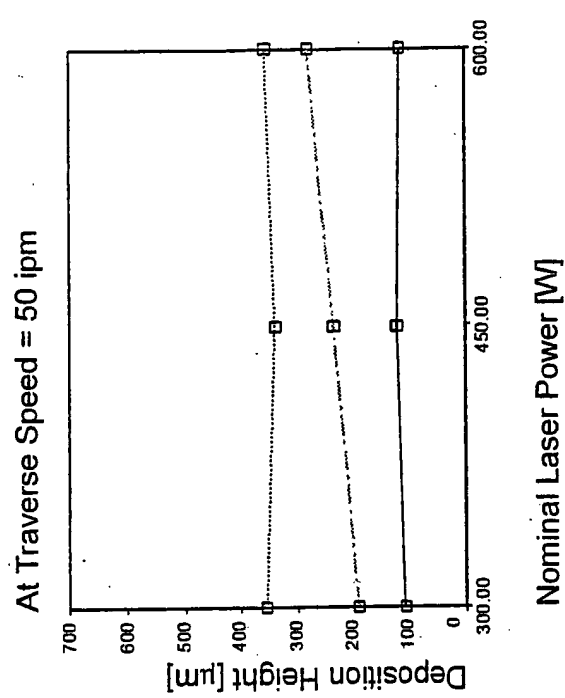
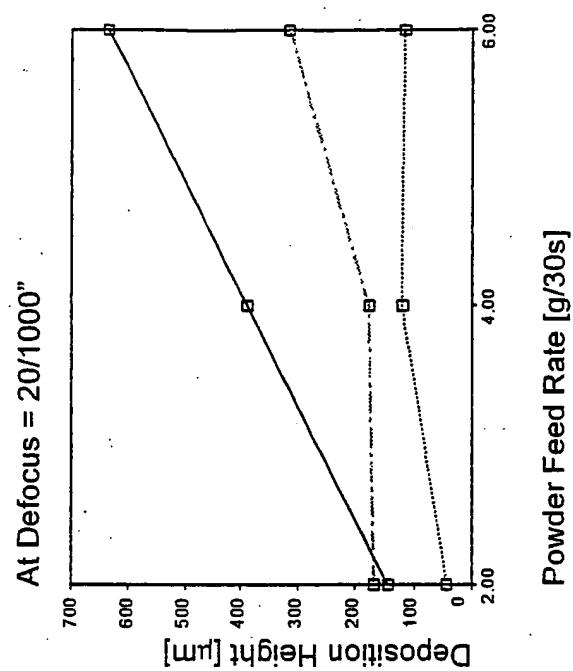
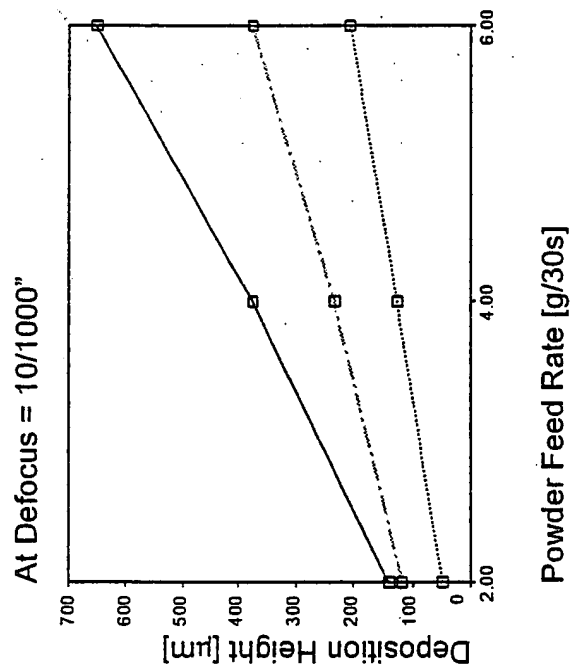


FIGURE 11



Traverse Speed [ipm]

- 75
- 50
- 25



At Defocus = 30/1000"

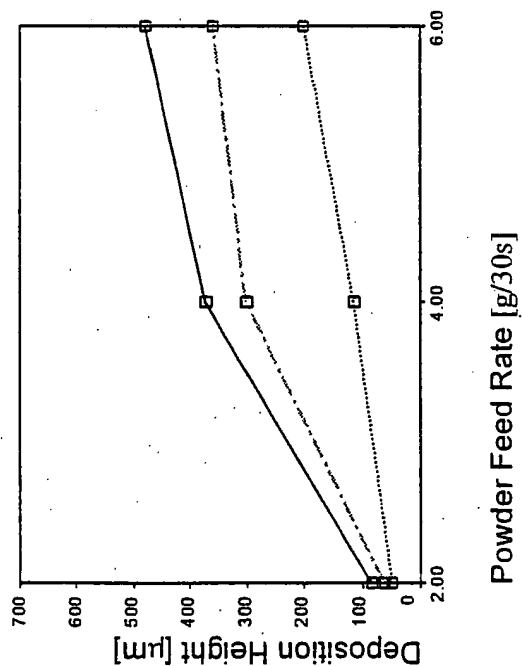
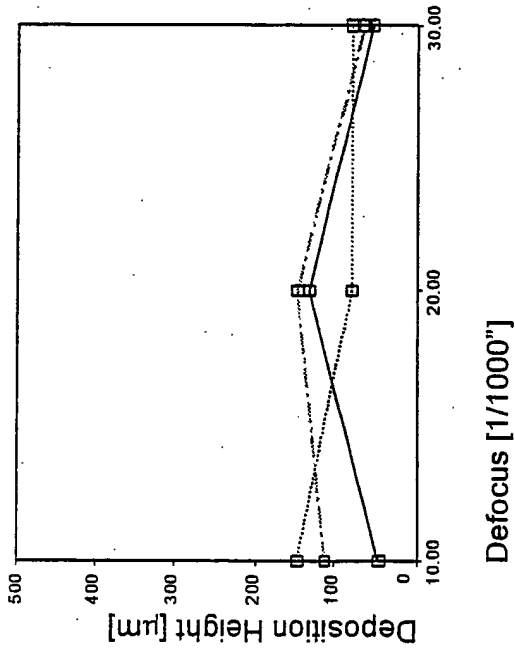


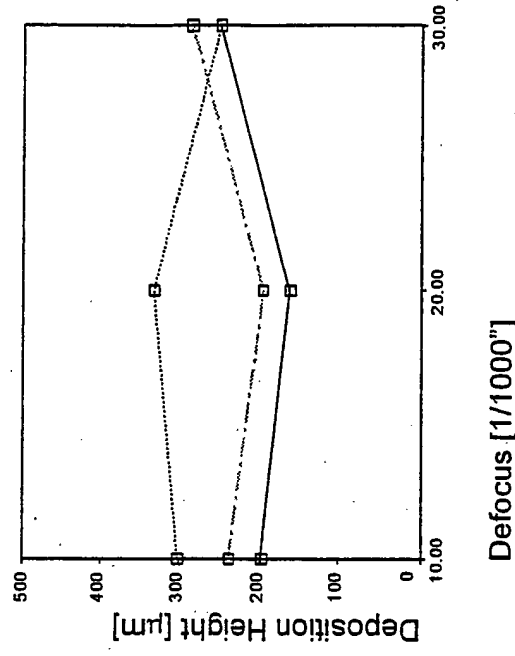
FIGURE 12



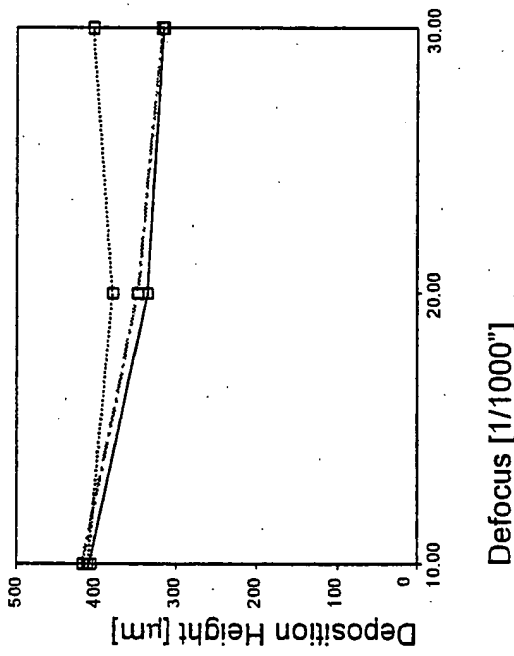
At Powder Feed Rate = 2 g/30s



At Powder Feed Rate = 4 g/30s



At Powder Feed Rate = 6 g/30s



Nominal Laser Power [W]

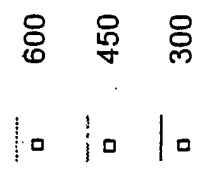


FIGURE 13



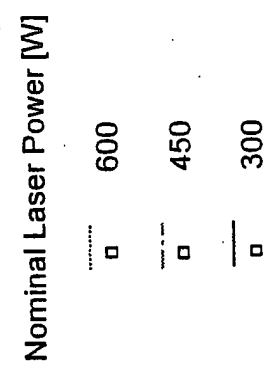
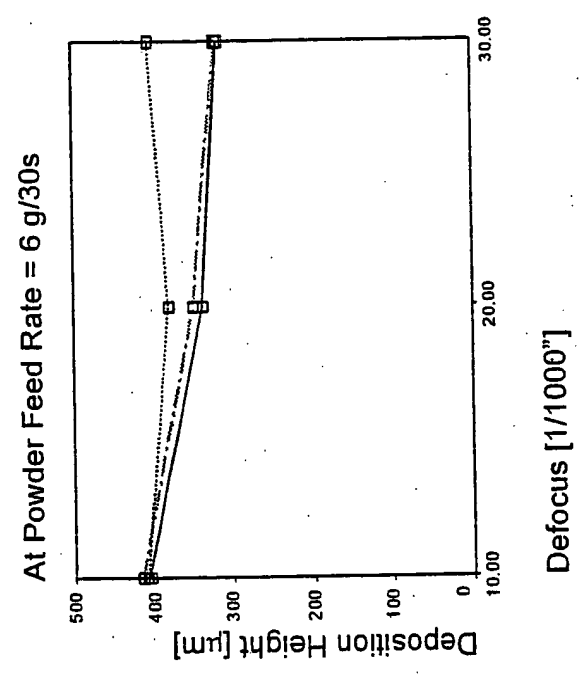
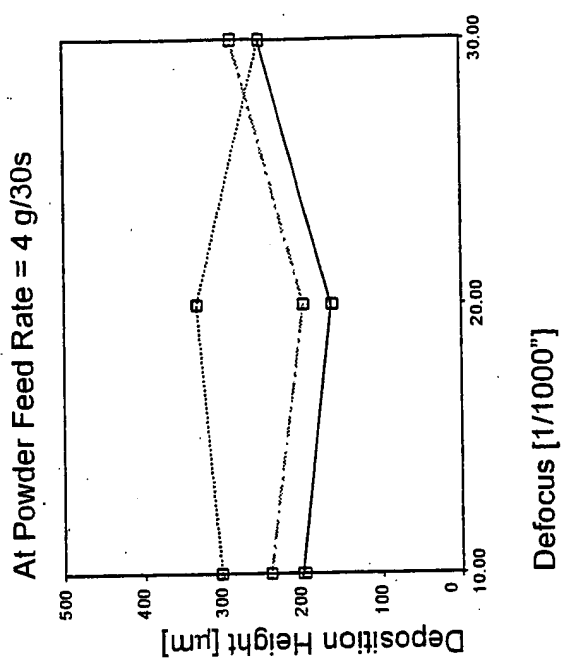


FIGURE 14